

Date: Monday, 04/06/2007 8:19:20 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET
Job Number	32747	Part Number	D32941
Estimate Number	11181	Drawing Number	D3294 REV A1
P.O. Number	N/A	Project Number	N/A
This Issue	04/06/2007	S.O. No.	<i>1104</i>
Prsh Rev.	NC	Drawing Revision	A1
First Issue	<i>N/A</i>	Material	N/A
Previous Run	32095	Due Date	11/06/2007
Written By		Qty:	
Checked & Approved By		Um:	Each
Comment	Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet
		Comment: Qty.: 2.1072 sf(s)/Unit Total: 16.5600 SF(S) 6.8580 Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3294-1 Batch: M104464 ml 07 06 04
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3294 Dwg Rev: A1 ml 07 06 04 Prog Rev: A1
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		ml 07 06 04
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Sn 07/06/04
		Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/06/2007 8:19:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32747

Part Number: D32941

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



SB 07/06/04 8

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

6.0 BRAKE NC NC BRAKE



SB 07/06/04 8

Comment: NC BRAKE

Form as per Dwg D3294

7.0 QC5 INSPECT WORK TO CURRENT STEP



SA 07/06/04 8

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



SA 07/06/04 8

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0 POWDER COATING POWDER COATING



07-06-05 8

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



07/06/05 8

Comment: INSPECT CHEMICAL CONVERSION COAT

M-1 07/06/05

11.0 PACKAGING 1 PACKAGING RESOURCE #1



8X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/05 8x

12.0 QC21 FINAL INSPECTION/W/O RELEASE



07/06/05 8

Comment: FINAL INSPECTION/W/O RELEASE

07/06/05 8

Job Completion



N 07-06-05 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

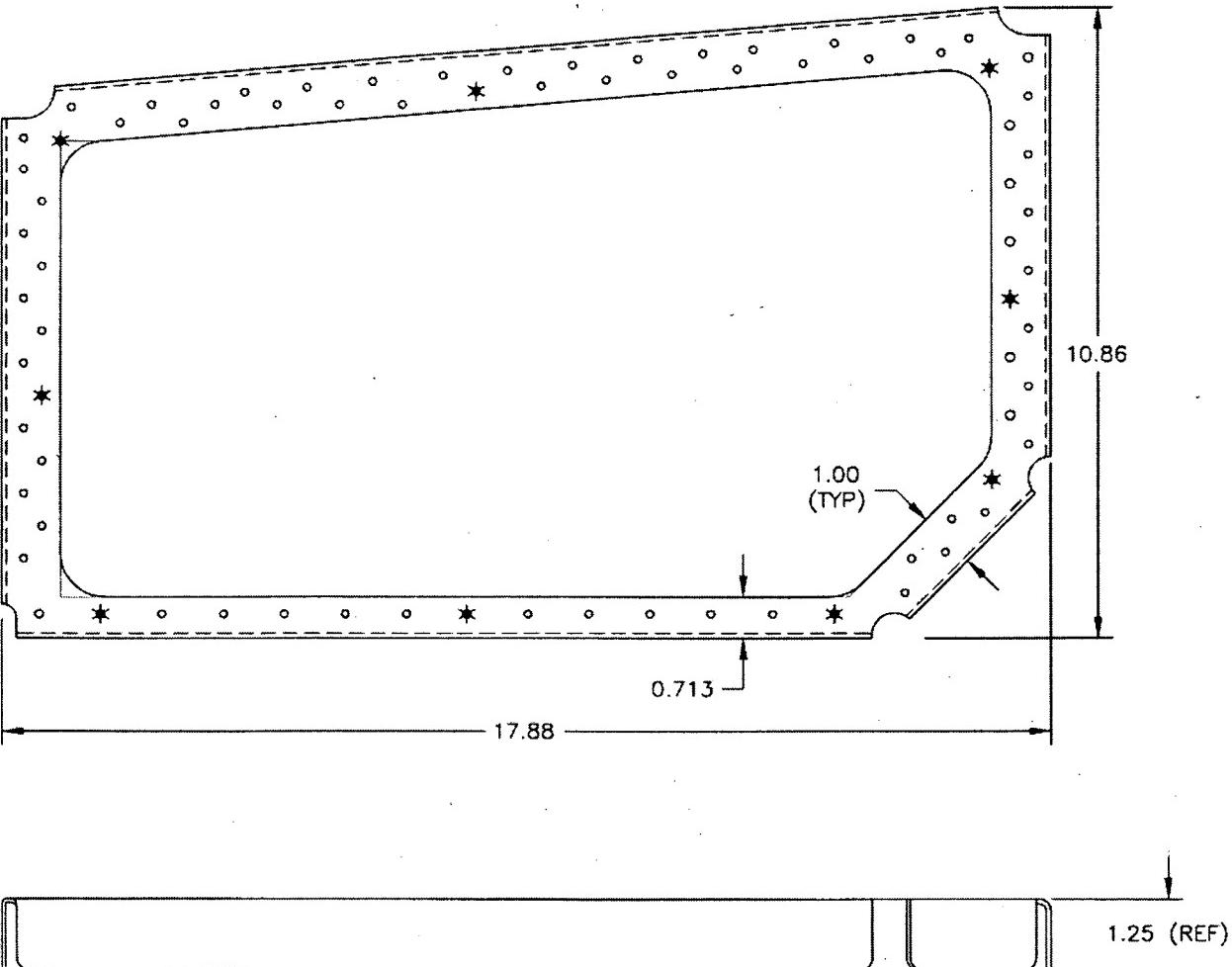
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3294-1 BRACKET

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DART

© DART 2004

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A
SHEET 1 OF 2

DESIGN	DRAWN BY	APPROVED	DRAWING NO.	TITLE	SCALE
A	if	if	D3294	BRACKET	1:3

RELEASED

04.07.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

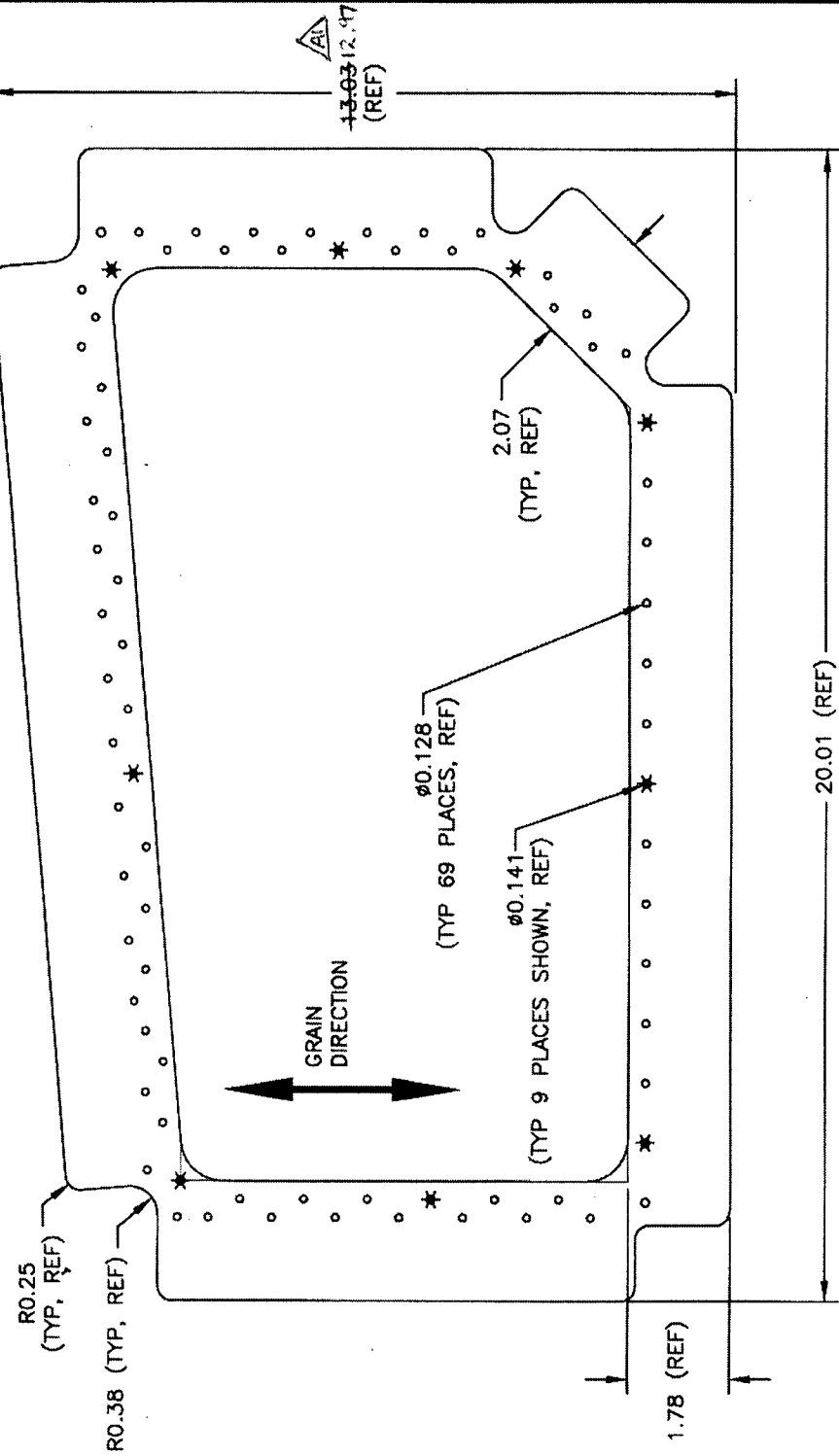
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3294 REV. A
DATE 04.06.28	TITLE BRACKET	SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED
04.07.12 *[Signature]*

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 32747

Description: Bracket

Part Number: D3294-1

Inspection Dwg: D3294

Rev: A1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.141$	+0.005-0.001	0.142	✓		VERN	
B $\phi 0.128$	+0.005-0.001	0.130	✓		VERN	
C 12.91	+1-0.030	12.97	✓		M.T	
D 20.01	+1-0.030	20.01	✓		M.T	
E 1.78	+1-0.030	1.783	✓		VERN	
F 2.07	+1-0.030	2.071	✓		VERN	
G R0.25	+1-0.030	R0.25	✓		RG	
H R0.38	+1-0.030	R0.38	✓		RG	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	<i>M. M</i>
Date:	07/06/04

Audited by:	<i>S.</i>
Date:	07/06/04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	